

Work Order ID 63126

Thursday, October 28, 2010 3:37:36 PM

**DUPLICATE**

Page 1

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Lid Assembly (350)

Stop



Start Date: 10/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MW

Date: 10-10-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4018

C

100



Large Fab

Weld per dwg A/R S.S. rod Batch: *11/4619* 0.00

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

M 10/10/28 (1x)

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

Cpl 10.10.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date: _____

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Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/10/28

④

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

*** mask sides of hinge prior to powdercoat***

Start Time: 8:10

Oven Temperature: 220

Finish Time: 8:40

1 BLW-W-1

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

M115790-7 H 10/11/10

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
2- install label

1 0

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Start Date: 10/21/2010 Start Qty: 1.00



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Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>EP 10/11/03</i> ①
160 Packaging Packaging	Identify as per dwg & Stock Location: <i>C-A</i> Memo <i>W/P 63123</i>	0.00 0.00							<i>EP 10/11/03</i> ①
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/11/03</i> ② <i>MF</i> <i>10-11-3</i>

W/O:		WORK ORDER CHANGES						
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Thursday, October 28, 2010 3:37:36 PM

...the

[illegible]

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1  Rib		Manufactured	No			100	Each	4.0000	2	2		10/10/29	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
					59252			4					
D4018-3  Rib		Manufactured	No			100	Each	4.0000	2	2		10/10/29	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
					59253			4					
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	10.0000	3	3		10/10/29	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST116				6					
					60723			6					
				WA				4					
					60548			4					

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Picklist Print

Thursday, October 28, 2010 3:37:36 PM

Page 2

Work Order ID: 63126

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 10/21/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D4018-5

Manufactured No

100

Each

21.0000

6

6



Rib



10/10/29

Location

Loc Qty

Loc Code

WA

21

59929

21

D4035-041

Manufactured No

100

Each

4.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



10/10/29

Location

Loc Qty

Loc Code

WA

4

60546

2

61066

2

D4035-043

Manufactured No

100

Each

4.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



10/10/29

Location

Loc Qty

Loc Code

WA

4

60475

2

61067

2

D2581

Manufactured No

100

Each

31.0000

2

2



Mounting Bracket



10/10/29

Location

Loc Qty

Loc Code

WA

31

60470

11

61953

20

2

Thursday, October 28, 2010 3:37:36 PM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 63126

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 10/21/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D4020-7

Manufactured No

100

Each

1.0000

1

1



Mesh (350 Basket Short, Lid)



JS 10/10/28

Location

Loc Qty

Loc Code

FG

1

59610

1

D4021-3

Manufactured No

100

Each

5.0000

1



Data Plate



JS 10/10/28

Location

Loc Qty

Loc Code

WA

5

56050

1

59987

2

60734

2

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



B# 115050

ml 10 11 03 (1)

Thursday, October 28, 2010 3:37:36 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
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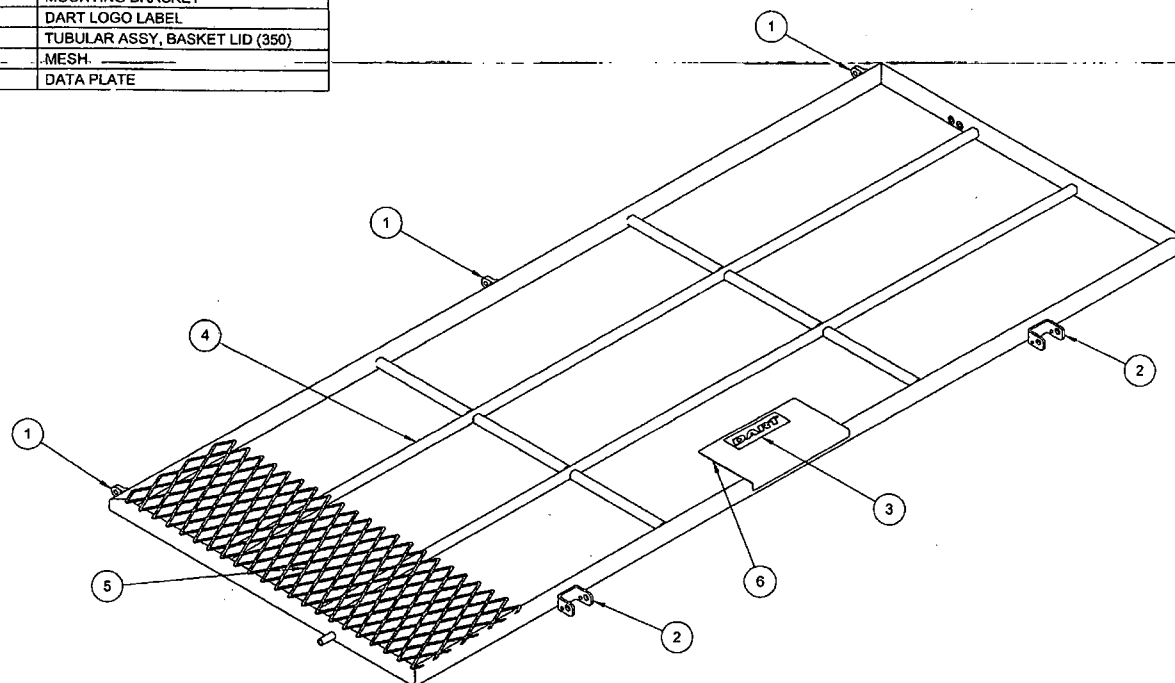
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ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12
ECN 10-96

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	10.08.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4018** REV. C
SHEET 1 OF 4

TITLE **SHORT BASKET LID ASSY (350)** SCALE NTS.

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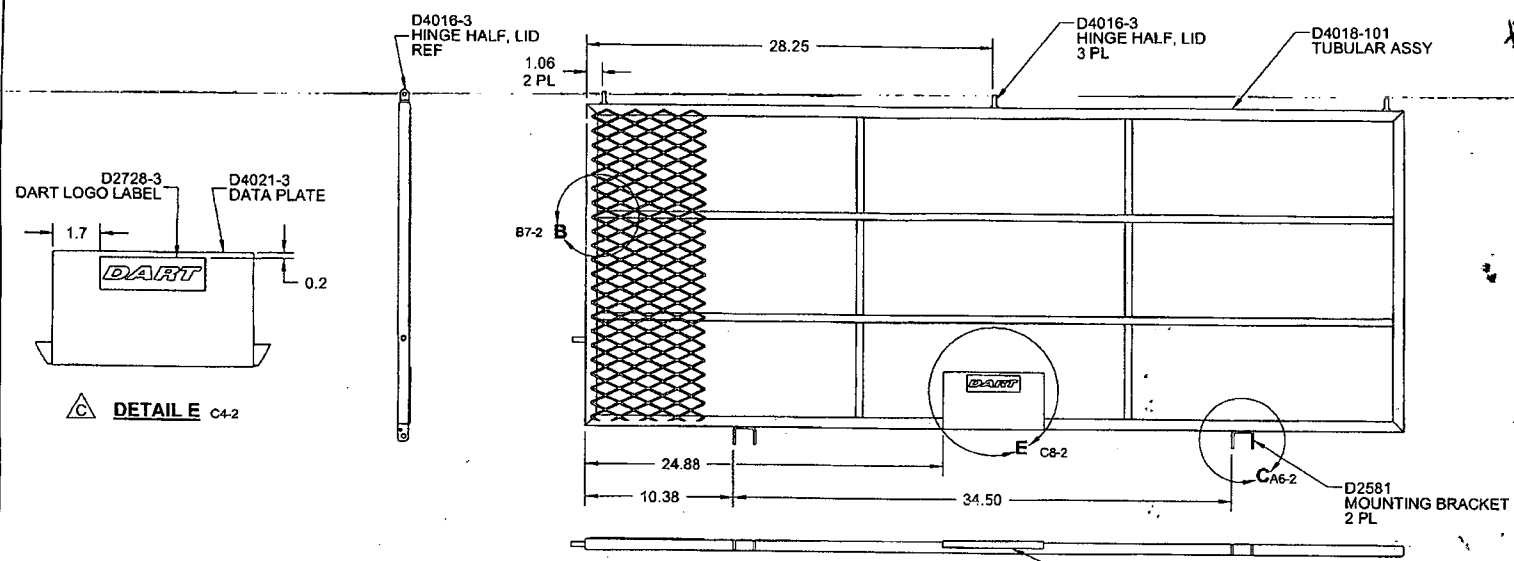
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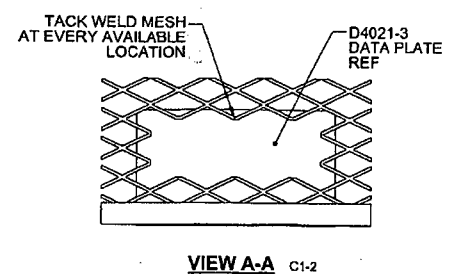
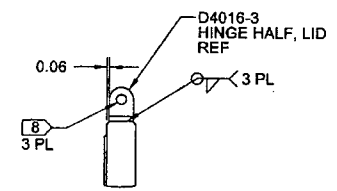
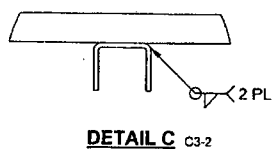
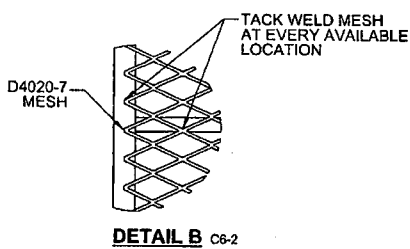
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#63124



DETAIL E C4-2



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10 08 05

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DETAIL D D1-2

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

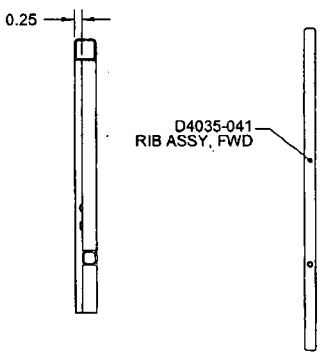
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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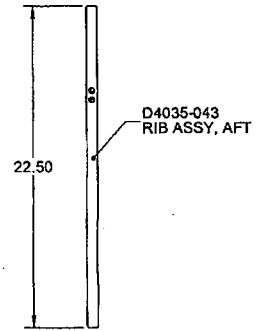
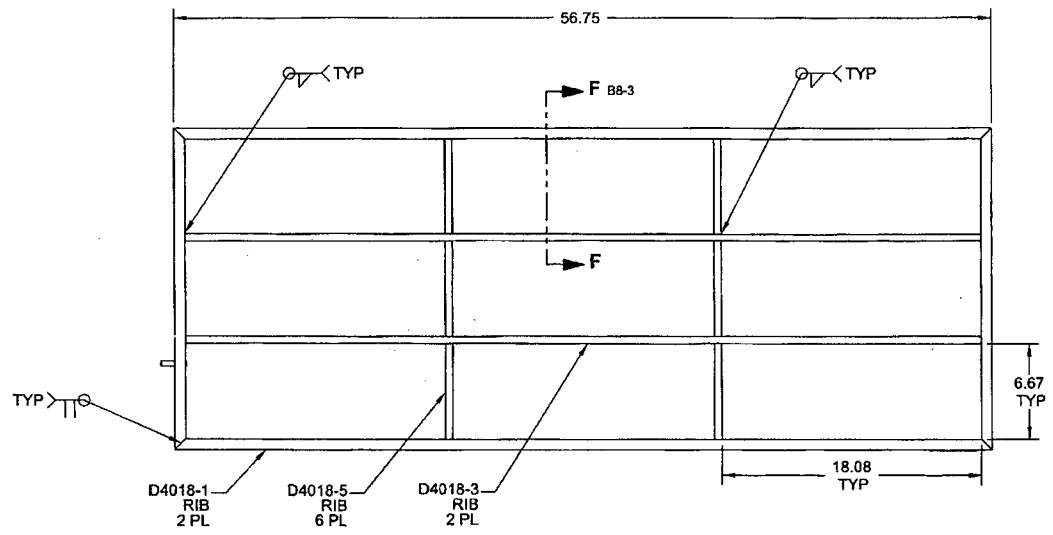
NOTE: Date & initial all entries

#63126

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION F-F C3-3



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.06 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SL	DRAWING NO.	REV. C
MFG. APPR.	SL	D4018	SHEET 3 OF 4
APPROVED	SL	TITLE	SCALE
DE APPR.	SL	SHORT BASKET LID ASSY (350) NTS	
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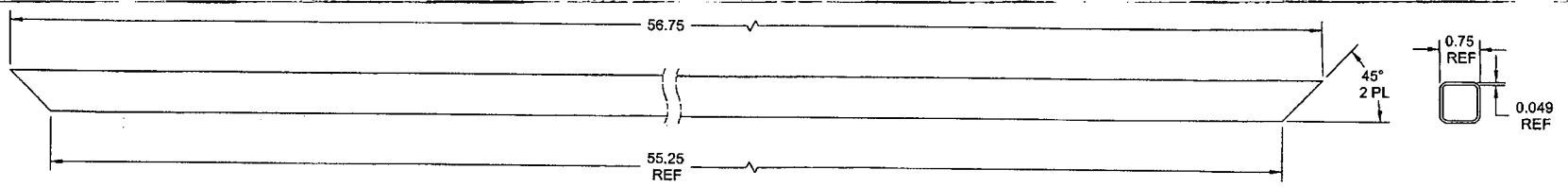
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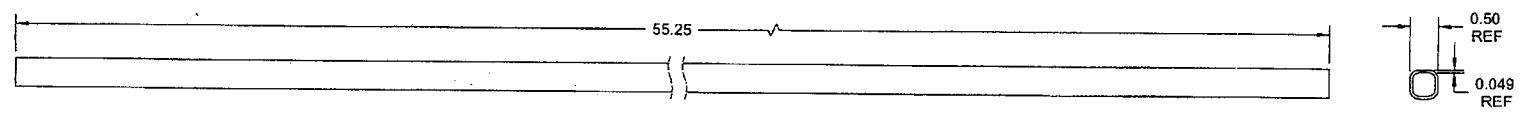
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D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

RELEASED
10.08.05

NOTES:
 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
 REF DART SPEC. M304TS0.750W.049
 -3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
 REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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